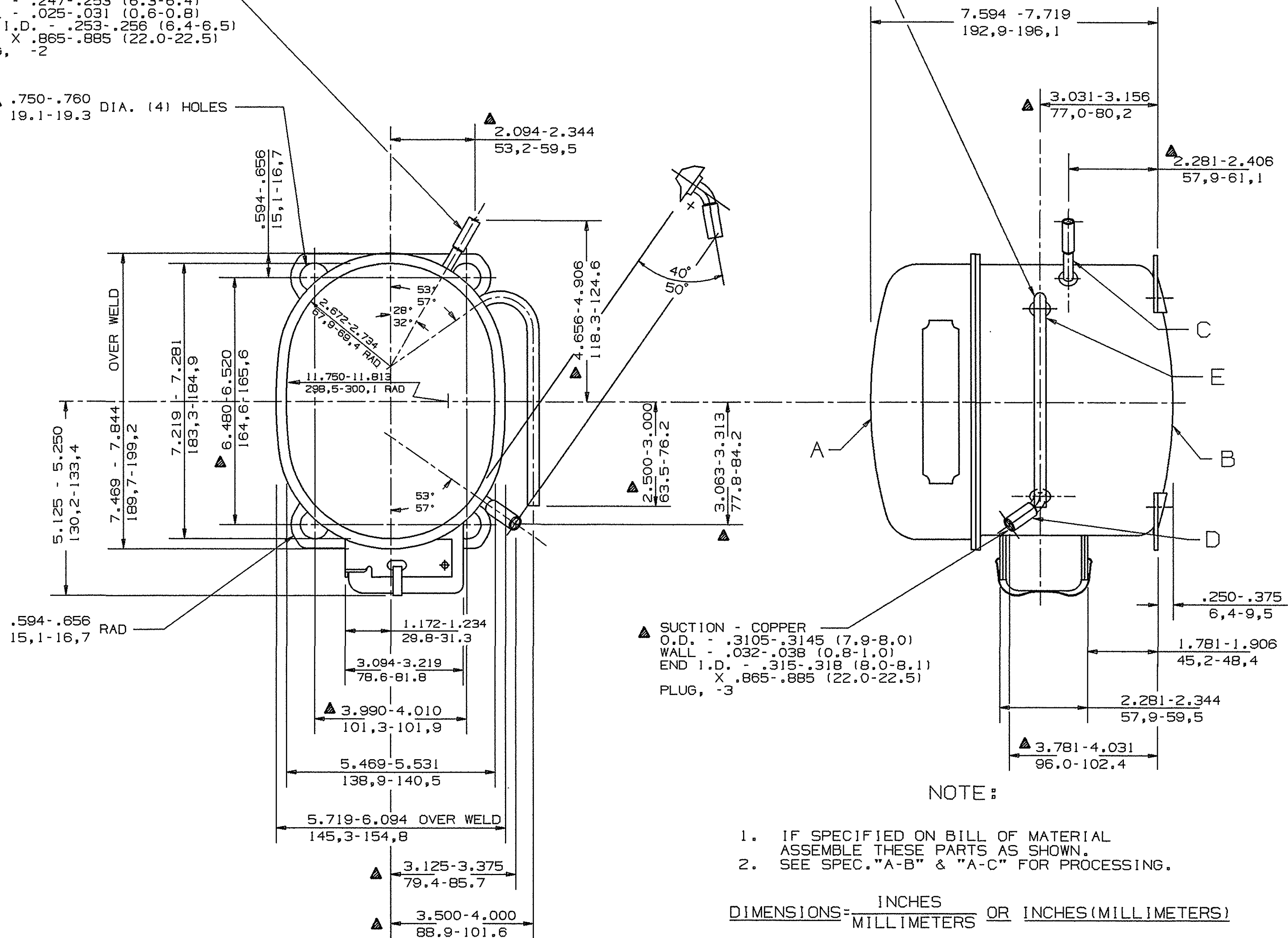


▲ DISCHARGE - STEEL  
O.D. - .247-.253 (6.3-6.4)  
WALL - .025-.031 (0.6-0.8)  
END I.D. - .253-.256 (6.4-6.5)  
X .865-.885 (22.0-22.5)  
PLUG, -2

▲ .750-.760 DIA. (4) HOLES  
19.1-19.3

▲ PROCESS - COPPER  
O.D. - .3105-.3145 (7.9-8.0)  
WALL - .0255-.0305 (0.6-0.8)  
PLUG, -2



▲ SUCTION - COPPER  
O.D. - .3105-.3145 (7.9-8.0)  
WALL - .032-.038 (0.8-1.0)  
END I.D. - .315-.318 (8.0-8.1)  
X .865-.885 (22.0-22.5)  
PLUG, -3

NOTE:

1. IF SPECIFIED ON BILL OF MATERIAL ASSEMBLE THESE PARTS AS SHOWN.
2. SEE SPEC. "A-B" & "A-C" FOR PROCESSING.

DIMENSIONS = INCHES OR INCHES (MILLIMETERS)  
MILLIMETERS

Q.A. SYMBOLS  
★ = CATEGORY I  
▲ = CATEGORY II  
■ = CATEGORY III  
□ = CATEGORY IV

|   |          |
|---|----------|
| A | 32095    |
| B | HA531-12 |
| C | 34574    |
| D | 34575    |
| E | 34442    |

PK

| Q.A. SYMBOLS                                  | DATE    |
|-----------------------------------------------|---------|
| ADDED #221145                                 | 1/23/90 |
| PROCESS TUBE RELOCATED TO HORIZ. POS. #213768 | 4-10-88 |
| REDRAWN NO CHANGE                             | 4-10-88 |
| LC                                            | 212377  |

| DATE    | DATE    |
|---------|---------|
| 1/23/90 | 4-10-88 |
| 4-10-88 | 4-10-88 |
| 4-10-88 | 4-10-88 |
| 4-10-88 | 4-10-88 |

|                                          |                       |              |             |                                           |
|------------------------------------------|-----------------------|--------------|-------------|-------------------------------------------|
| DWG. BRODERICK 4-10-86                   | CK. MITAUGHET 1-26-90 | APR. BLANDEN | SCALE 1"=2" | THIS PRINT SUPERSEDES ALL PRINTS PRIOR TO |
| TECUMSEH PRODUCTS CO. TECUMSEH, MICHIGAN |                       |              |             | PART NO.                                  |
| MATERIAL NOTED                           |                       |              |             | DCAE-616                                  |
| INTERNAL USE ONLY                        |                       |              |             |                                           |